



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117-12010W66-7
Job Sheet 185130



7154
Dec 3

Part No: RBE117-12010W66-7

Job Qty: 4 ea

Part Name: Hinge Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-12010W66 Rev. 1 IPP Rev. A 18.09.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Machining-3		FRED 18-11-19
110	Lathe Conv	4 pcs	11/30/18	11/30/18	0.00	2.00	Lathe Conv-1		FRED 18-11-19
120	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC2 Machining-4		FRED 18-11-19
130	Mill Conv	4 pcs	11/30/18	11/30/18	0.00	1.00	Mill Conv 1		FRED 18-11-19
140	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC2 Machining-4		FRED 18-11-19
150	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC8 Machining-4		FRED 18-11-19
180	Outsource	4 pcs	11/30/18	11/30/18			GRO002-VC		18/11/19
190	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging2		NOV 20 2018
200	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC6		38
210	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		GA
220	QC21-SA	4 Ea	11/30/18	11/30/18	0.00	0.00	QC21		DEC 05 2018

Part Op 110 - 1-Machine as per DWG. 2-Deburr
Descriptions: 130 - 1-Machine as per DWG. 2-Deburr

180 - -Issue P/O to GROUPE ALTECH; PO 041876 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R0.500	1018-1025 round bar .500	.3000 ft (.075 ea)	90-Start up Operation	5013212

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R0.500	0	32	0



Container No: S128877



Part: RBE117-12010W66-7

Job No: 185130

Serial No/Batch: S128877

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ions

ot be found.

Plex 10/23/18 8:04 AM Dart.lajeunesse.marie

Date: 11/19/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

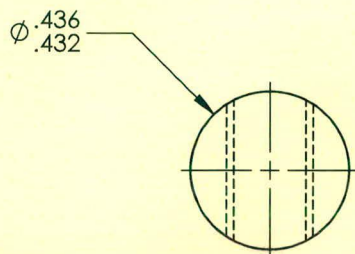
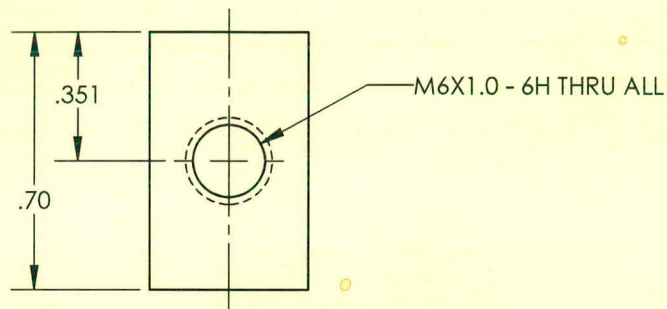
QA Closed: _____ Date: _____

Work Order update only ☐

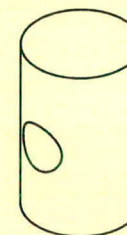
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



(-7)
HINGE BLOCK



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 185730 MW
1870-23

DART AEROSPACE	
TITLE GUARD	
DWG NO. RBE117-12010W66-7	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH BLACK OXIDE	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC QMSI-6.2.2 REV D	.X $\pm$.1 SURFACES = 125/
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC 145
SCALE 2:1	DATE 2/23/2016
SHEET 5 OF 5	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041846**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041846
PO Date: 11/26/18
Due Date: 11/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60

Freight Terms:

Special Comments: ** Please confirm if we can get parts back by line date **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178486	RBT18560-5	Screw -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/30/18	8 pcs	0 pcs	8 pcs	\$10.00/pcs	\$80.00
84 NOV 30 2018											
Line Item Note ** need by Nov. 30, is this possible? **											
2	185130	RBE117-12010W66-7	Hinge Block -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/30/18	4 pcs	0 pcs	4 pcs	\$10.00/pcs	\$40.00
44 NOV 30 2018											
Line Item Note ** need by Nov. 30, is this possible? **											

DAS
38
9-88



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PURCHASE ORDER

PO041846

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/26/18 9:12 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014775-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014775- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
30-Nov-2018		Aman				041846				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir / Back Order
1	RBT18560-5 Rev.	RBT18560-5 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1		BLACK-OXIDE CH	8	8	0	0	0	
2	RBE117-12010W66-7 Rev.	RBE117-12010W66-7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS OIL		BLACK-OXIDE CH	4	4	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

